

SHIP Wed 22/11

Dart Aerospace Ltd.

Date: Monday, 11/20/2006 11:33:14 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: STEP WELDMENT		
Job Number	: 29537					
Estimate Number	: 10176					
P.O. Number	: N/A			Part Number	: D2563	
This Issue	: 11/20/2006 S.O. No. : N/A			Drawing Number	: D2563 REV C	
Prsht Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: C	
Previous Run	: 28788			Material	: N/A	
Written By	: <u>AB</u>			Due Date	: 11/27/2006	
Checked & Approved By	: <u>AB</u> 11/20			Qty:	2 Um: Each	
Comment	: Est Rev: 02.07.31 Re-format Location RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D2244116	Step Extrusion	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		1 D2244 Step Extrusion	
		Batch: <u>B23404</u>	PD 06-11-20 (2)
2.0	D267334	End Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description Batch	
		2 D2673-34 End Cap <u>B2539b</u>	
			PD 06-11-20 (2)
3.0	D2561	Lug Plate	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description Batch	
		2 D2561 Lug Plate <u>B244b1</u>	
			PD 06-11-20 (2)
4.0	D2564	Mounting Angle	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part No. Description Batch	
		2 D2564 Mounting Angle <u>B2741B</u>	
			PD 06-11-20 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Cut D2244 to 89.70" at 34° as per Dwg D2563		
2-Deburr ends		
3-Weld (1 End CAP,LUG PLATES & MOUNTING ANGLE as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <u>M101446</u>		
4-Grind		PD 06-11-20 (2)
6.0	QC5/9	WELD INSPECTION
Comment: WELD INSPECTION		<u>11/06/11/21</u> (2)
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1		PD 06-11-21 (2)
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		<u>11. 06 - 11 - 21</u> (2)
9.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
1-Inspect for foreign object per QSI 024		
2-Weld Remaining End as per Dwg D2563 using DT 8343 A/R AL ROD Batch: <u>M118838</u>		
3-Grind		<u>11. 06 - 11 - 21</u> (2)
10.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		<u>11/06/11/21</u> (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/22
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 29537		Part Number: D2563
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
11.0	QC5	INSPECT WORK TO CURRENT STEP 
Comment: INSPECT WORK TO CURRENT STEP		 11/06/11/21 (2)
12.0	POWDER COATING	POWDER COATING 
Comment: POWDER COATING Touch up Alodine then a.m 06/11/21 Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3		 a.m 06/11/22 (3)
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D2563 and QSI 005 4.4		 M 102635 a.m 06/11/22 (3)
14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		 FC 06/11/22 (3)
15.0	QC21	FINAL INSPECTION/W/O RELEASE 
Comment: FINAL INSPECTION/W/O RELEASE		 06/11/22 (3)
Job Completion W 146 Package per PPP D205633 U 06/11/22 R 06/11/22 (2)		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

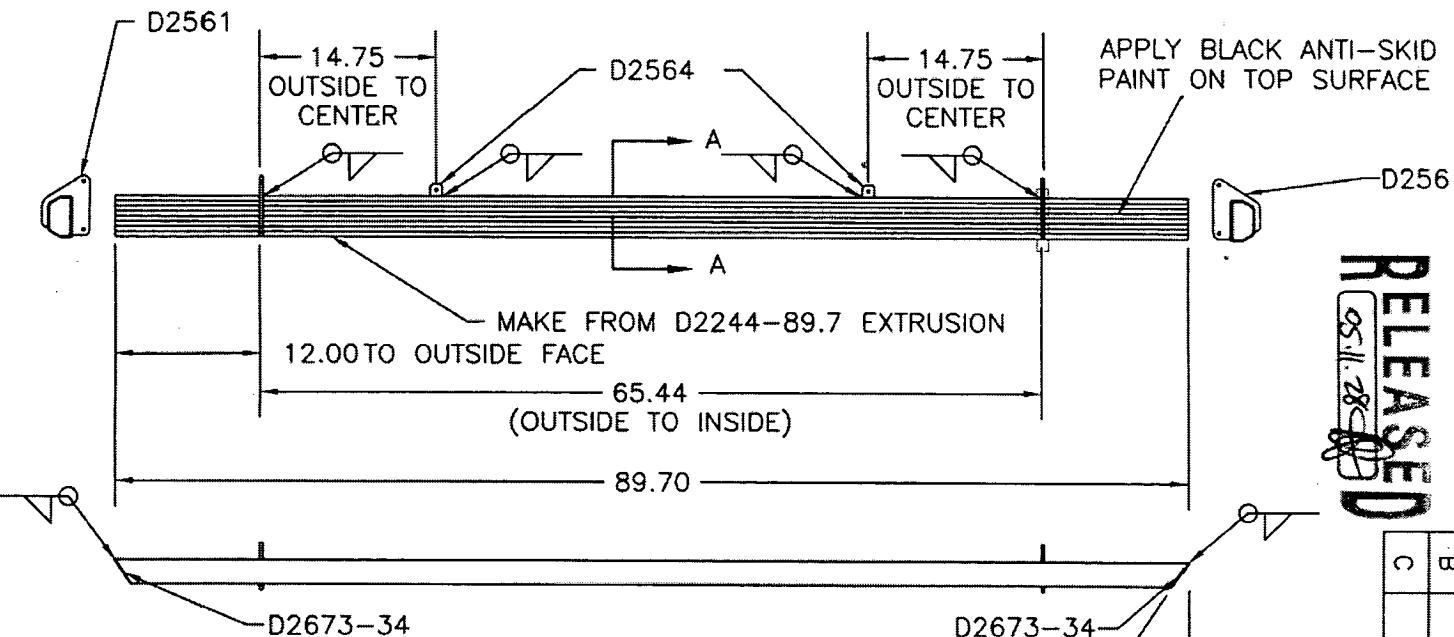
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN
BW
DRAWN BY
44
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
REV. C

DATE	APPROVED	TITLE	SCALE
05.11.14	44	D2563 STEP WELDMENT ASSEMBLY	1:15
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	

RELEASED
05.11.28.00**D2563 STEP WELDMENT ASSEMBLY PARTS LIST**

Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED